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D4956-23
Job Sheet 202819



Part No: D4956-23

Job Qty: 16 pcs

Part Name: Wearplate Center Fwd



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/4/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: Stock *SOLD*

Description:

Note: DWG REV A SHEETS 4,8 IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	16 pcs		11/29/19	0.17	4.43	Waterjet - Flow		<i>219/11/16</i>
120	QC 8	16 pcs		11/29/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		<i>NOV 22 2019</i>
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
130	Small Fab - Brake NC - B4B	16 pcs		11/29/19	0.25	0.72	Small Fab - Brake - 1 - B4B		<i>NOV 25 2019</i>
							Small Fab - Brake - 2 -		

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				B4B	
				Small Fab - Brake - 3 - B4B	
140 QC 5	16 pcs	11/29/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150 Handfinish - 4-1-Assembly-B4B	16 pcs	11/29/19	0.00 1.55	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
160 QC 3	16 pcs	11/29/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	

DAS
NOV 28 2019 40
8-89

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DAS
NOV 30 2019 40
8-89

				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
170 Packaging 3-1 - Stock - B4B	16 pcs	11/29/19	0.00 0.00	Packaging 3 - 1 - B4B	Sp-002 21 14-12-02
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	16 pcs	11/29/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAS
				QC 21 - SA - 53	21
Part Op 100 - (Waterjet - Flow) Descriptions: 120 - (QC8- Inspect parts - second check) 130 - (Form as per dwg) 140 - (QC5- Inspect part completeness to step on W/O) 150 - (Assemble as per dwg) 160 - (QC3- Inspect Part Finish) 170 - (Identify as per dwg & Stock Location: _____) 180 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M304S20GA	304/316 .040 Sheet	20 sf (1.25 ea)	100-Waterjet - Flow - 1	S200296	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S20GA	20	35	0
Part Specifications				
Spec No	Description	Target/Tolerance	Limits	Type Special Comments
1	Wearshoe	0.188Inches + 0.005 - 0.001	0.193 0.187	Diameter
2	Wearshoe	0.300Inches ± 0.010	0.310 0.290	
3	Wearshoe	0.300Inches ± 0.010	0.310 0.290	
4	Wearshoe	1.885Inches ± 0.010	1.895 1.875	
5	Wearshoe	2.000Inches ± 0.010	2.010 1.990	
6	Wearshoe	6.750Inches ± 0.010	6.760 6.740	
7	Wearshoe	11.500Inches ± 0.010	11.510 11.490	
8	Wearshoe	16.750Inches ± 0.010	16.760 16.740	
9	Wearshoe	25.140Inches ± 0.010	25.150 25.130	
10	Wearshoe	30.530Inches ± 0.010	30.540 30.520	
11	Wearshoe	35.920Inches ± 0.010	35.930 35.910	
12	Wearshoe	41.310Inches ± 0.010	41.320 41.300	
13	Wearshoe	46.700Inches ± 0.010	46.710 46.690	
14	Wearshoe	50.200Inches ± 0.010	50.210 50.190	
15	Wearshoe	54.850Inches ± 0.010	54.860 54.840	
16	Wearshoe	56.850Inches ± 0.030	56.880 56.820	
17	Wearshoe	6.000Inches ± 0.030	6.030 5.970	
18	Wearshoe	14.000Inches ± 0.030	14.030 13.970	
19	Wearshoe	22.000Inches ± 0.030	22.030 21.970	
20	Wearshoe	30.000Inches ± 0.030	30.030 29.970	
21	Wearshoe	38.000Inches ± 0.030	38.030 37.970	
22	Wearshoe	45.000Inches ± 0.030	45.030 44.970	
23	Wearshoe	54.000Inches ± 0.030	54.030 53.970	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date :	Sequence #:	QTY Affected :		MRB (QSI042)
Description Work Order Deviation		Disposition		Completed By
				Lead hand / Supervisor
				QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
Other/Details:				



Container No: S232473



Part: D4956-23

Job No: 202819

Serial No/Batch: S232473

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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